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D4522-041
Job Sheet 187093



Part No: D4522-041

Job Qty: 1 ea

Part Name: Door Latch Assembly, LH, Oem



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/27/18

Job Tracking No:

Due Date: 1/31/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV B IPP REV:A 11.12.21 NEW ISSUE DD VERF:JLM IPP REV:B AS PER REV.B 12/07/05 JFS
VERF: JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	1/31/19	1/31/19	0.00	0.00	Start Up Stores/Pkg-1		DAS
100	Packaging	1 pcs	1/31/19	1/31/19	0.00	0.00	Packaging1-5		36 DAS
110	Small Fab	1 pcs	1/31/19	1/31/19	0.00	7.43	Small Fab-7		9-89 36
120	QC	1 pcs	1/31/19	1/31/19	0.00	0.00	QC5		DAS 40 9-89 36
130	Packaging	1 pcs	1/31/19	1/31/19	0.00	0.00	Packaging3-2		9-89 36
140	QC21-SA	1 Ea	1/31/19	1/31/19	0.00	0.00	QC21		DAS 21 9-89 36

Part Op
Descriptions: 110 - ASSEMBLE DOOR LATCH AS PER DWG

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D4522-045 101	Base, Horizontal Swing Arm	1 Ea (1 ea)	90-Start up Operation	F87025
D4522-047 101	Base, Vertical Swing Arm	1 Ea (1 ea)	90-Start up Operation	F87024
D4522-049 102	Base, Latch Shaft	1 Ea (1 ea)	90-Start up Operation	F98248
D4522-1 100	Base Plate, Oem, LH	1 Ea (1 ea)	90-Start up Operation	F80470
D4522-11 101	Handle Shaft Arm	1 Ea (1 ea)	90-Start up Operation	F86618
D4522-13 101	Handle Shaft Adapter	1 Ea (1 ea)	90-Start up Operation	F87022
D4522-17 101	Linkage	2 Ea (2 ea)	90-Start up Operation	F98258
D4522-19 101	Linkage	2 Ea (2 ea)	90-Start up Operation	F83063
D4522-21 101	Linkage	2 Ea (2 ea)	90-Start up Operation	F98251
D4522-25 101	Latch Shaft	1 Ea (1 ea)	90-Start up Operation	F96085
D4522-9 102	Vertical Swing Arm	1 Ea (1 ea)	90-Start up Operation	F80395
D4529-041 102	Horizontal Swing Arm	1 Ea (1 ea)	90-Start up Operation	F137727
D4530-041 102	Latch Roller Assembly	1 Ea (1 ea)	90-Start up Operation	F114470
D4531-1 102	Latch Shaft Bracket	1 Ea (1 ea)	90-Start up Operation	F98254
D4574-1 102	Interior L-Handle, Modified	1 Ea (1 ea)	90-Start up Operation	F86628
D4588-1 103	Torsion Spring	1 Ea (1 ea)	90-Start up Operation	F78930
D4626 107	Spring	1 Ea (1 ea)	90-Start up Operation	F82005
MS16562-193	Spring Pin 316 X2	1 Ea (1 ea)	90-Start up Operation	F120229-15
MS16562-223	Spring Pin 316	1 Ea (1 ea)	90-Start up Operation	F1135536
MS16562-227	Spring Pin 316	1 Ea (1 ea)	90-Start up Operation	F120595
MS16624-4062	External Retaining Ring 316	1 Ea (1 ea)	90-Start up Operation	F122389
MS20392-1P41	Drilled Pin 313	1 Ea (1 ea)	90-Start up Operation	

007441

Plex 11/27/18 1:18 PM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

MS20392-1R27P	Drilled Pin	1 Ea (1 ea)	90-Start up Operation
MS20392-1R37P	Drilled Pin	1 Ea (1 ea)	90-Start up Operation
MS20392-1R9P	Not A Good Number	4 Ea (4 ea)	90-Start up Operation
MS20392-2R41P	Not A Good Number 313	3 Ea (3 ea)	90-Start up Operation
MS20995-C20	Lockwire GA119	1 ft (1 ea)	90-Start up Operation
MS24665-151	Cotter Pin 389	7 Ea (7 ea)	90-Start up Operation
MS24665-155	Cotter Pin 389	2 Ea (2 ea)	90-Start up Operation
MS24671-14	Flat Head Screw, Hex, #8 388	6 Ea (6 ea)	90-Start up Operation
MS24674-13	Drilled Cap Screw, #10 388	1 Ea (1 ea)	90-Start up Operation
NAS1149CN432R	Flat Washer 266	5 Ea (5 ea)	90-Start up Operation
NAS42DD628FC	Spacer 57550	1 Ea (1 ea)	90-Start up Operation

FM129686
 FM128430
 FM125769
 FM128441
 S134767
 S053251
 FM129163-40
 F120229
 F120305
 F105940
 FM133284-20

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D4522-045	1	9	0
	D4522-047	1	5	0
	D4522-049	1	5	0
	D4522-1	1	3	0
	D4522-11	1	9	0
	D4522-13	1	7	0
	D4522-17	2	11	0
	D4522-19	2	6	0
	D4522-21	2	15	0
	D4522-25	1	10	0
	D4522-9	1	5	0
	D4529-041	1	1	0
	D4530-041	1	4	0
	D4531-1	1	8	0
	D4574-1	1	6	0
	D4588-1	1	92	0
	D4626-1	1	5	0
	MS16562-193	1	66	0
	MS16562-223	1	20	0
	MS16562-227	1	93	0
	MS16624-4062	1	16	0
	MS20392-1P41	1	8	0
	MS20392-1R27P	1	0	0
	MS20392-1R37P	1	0	0
	MS20392-1R9P	4	0	0
	MS20392-2R41P	3	16	0
	MS20995-C20	1	0	0
	MS24665-151	7	108	0
	MS24665-155	2	216	0
	MS24671-14	6	54	0
	MS24674-13	1	22	0
	NAS1149CN432R	5	157	0
	NAS42DD628FC	1	141	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐												
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Dart Aerospace Ltd. 1270 Aberdeen Street, Hamilton, ON K8A 1K7 CANADA TEL: 905 613 632 - 5200 Email: sales@dartaero.com www.dartaerospace.com Container No: S158929 Part: D4522 - 041 Job No: 187093 Serial No/ Batch: S158929 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: Various STC's Date: 03/05/18				Completed By _____																												
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